

Work Order ID 58730

Page 1

May 18, 2010 7:55:32 AM

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Item Name: Fwd Upper Rib Assembly

Stop



Start Date: 5/18/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

CL

Date: 10/5/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4034	A

100



Weld per dwg A/R S.S. rod Batch: M111679

0.00

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

10.06.07

3



Pto →

2- Weld bushing in rib as per dwg

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

(3) PD 10.06.07

Quality Control

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8.10.06.07

(3)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4043-003 PAR #: 34 Fault Category: Loose Fkt NCR: Yes No DQA: Date: 10/06/04
 Resolution: rework Disposition: rework QA: N/C Closed: Date: 10/06/07

NCR: 58730		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/04	#100	welder welded the D2327-3 on wrong size of D4043-5. weld orientation to Dwg. R.L. LOA when welding	<u>DS412</u>	- Remove the D2327-3 - clean out & weld the new one into position as per drawing per QSL0004.	<u>PL</u> <u>10/06/04</u>	<u>S</u> <u>10/06/07</u>	<u>S</u> <u>10/06/07</u>	<u>S</u> <u>10/06/04</u>

NOTE: Date & initial all entries

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Stop



Start Date: 5/18/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionIdentify as per dwg & Stock Location: USASet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

SAP 10-06-07

(3)

0.00

Packaging

Memo

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/06/07 JF

MF
10-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58730



Parent Item: D4034-043



Parent Item Name: Fwd Upper Rib Assembly

Start Date: 5/18/10

Required Date: 5/25/10

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4034-1		Manufactured	No			100	Each	6.0000	1		<i>5/10.06.04</i>	
Rib												

Location		Loc Qty	Loc Code
WA	358693	6	3
	200003	6	

D4034-5	Manufactured	No	100	Each	3.0000	1	<i>5/10.06.04</i>
Rib							

Location		Loc Qty	Loc Code
WA	358694	3	3
	58407	3	

D2327-3	Manufactured	No	100	Each	4.0000	1	<i>5/10.06.04</i>
Spacer Bushing							

Location		Loc Qty	Loc Code
WA	358406	4	3
	57790	4	

D4021-7	Manufactured	No	100	Each	5.0000	1	<i>5/10.06.04</i>
Hoop							

Location		Loc Qty	Loc Code
WA	358702	5	2
	58039	1	
	58484	4	1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

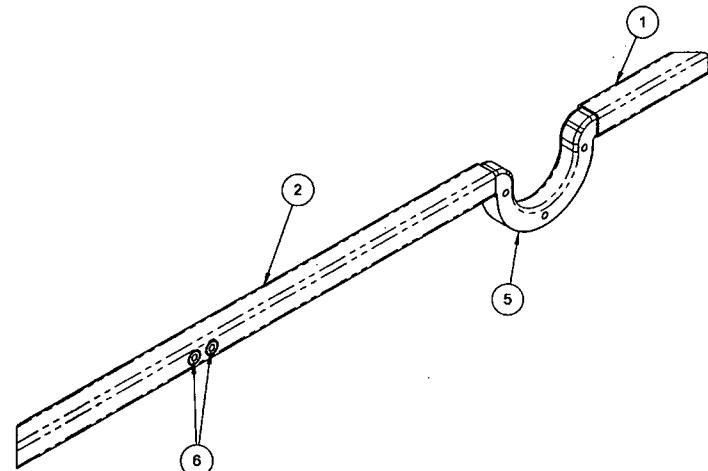
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

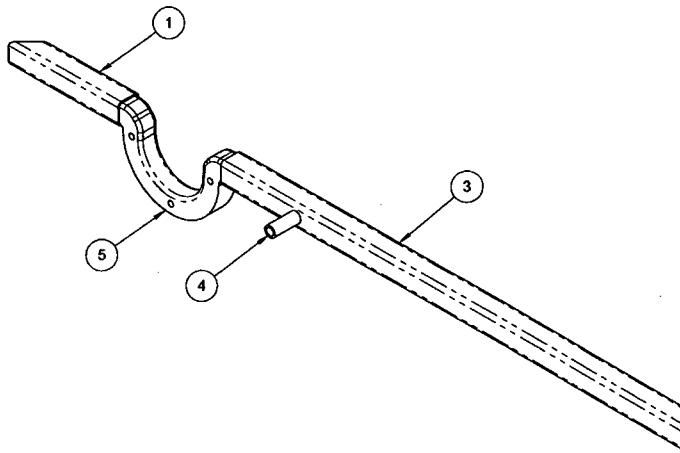
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING

CL101518
W10: 58730



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
JMP

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	00	DRAWING NO.	REV. A
MFG. APPR.	00	D4034	SHEET 1 OF 4
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.03.04	COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

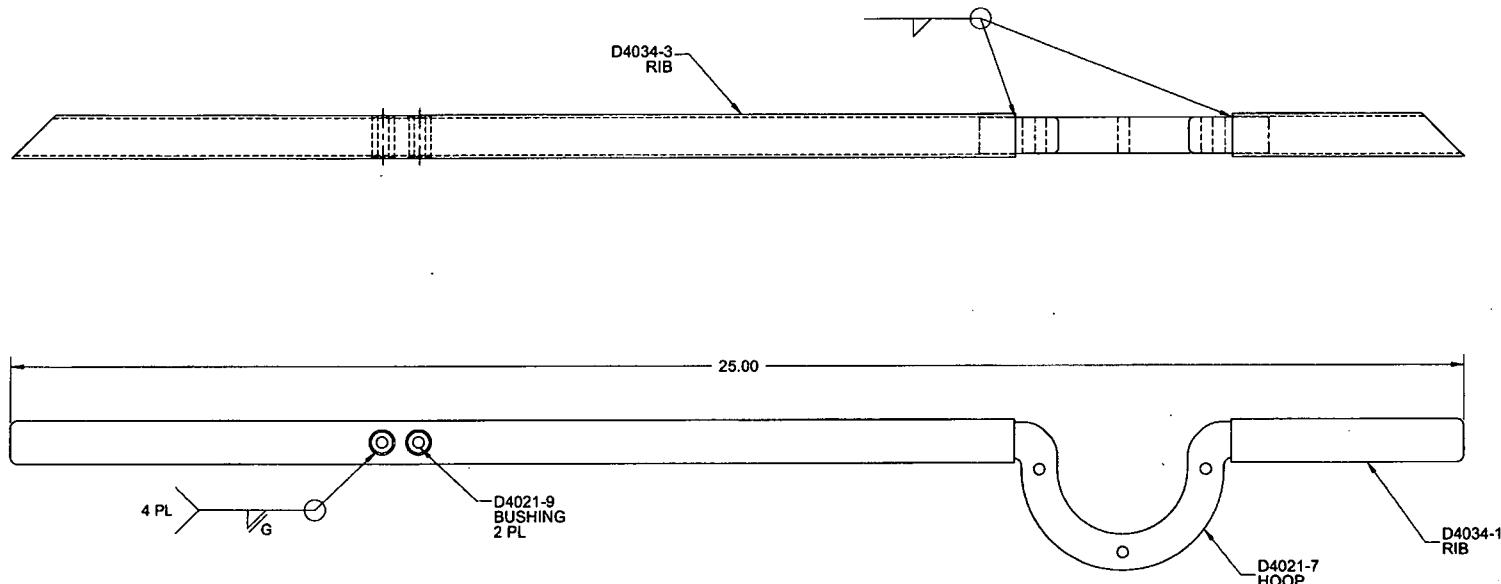
C

B

B

A

A

D4034-041 AFT UPPER RIB ASSY

RELEASED
2010-03-12
M

NOTES:

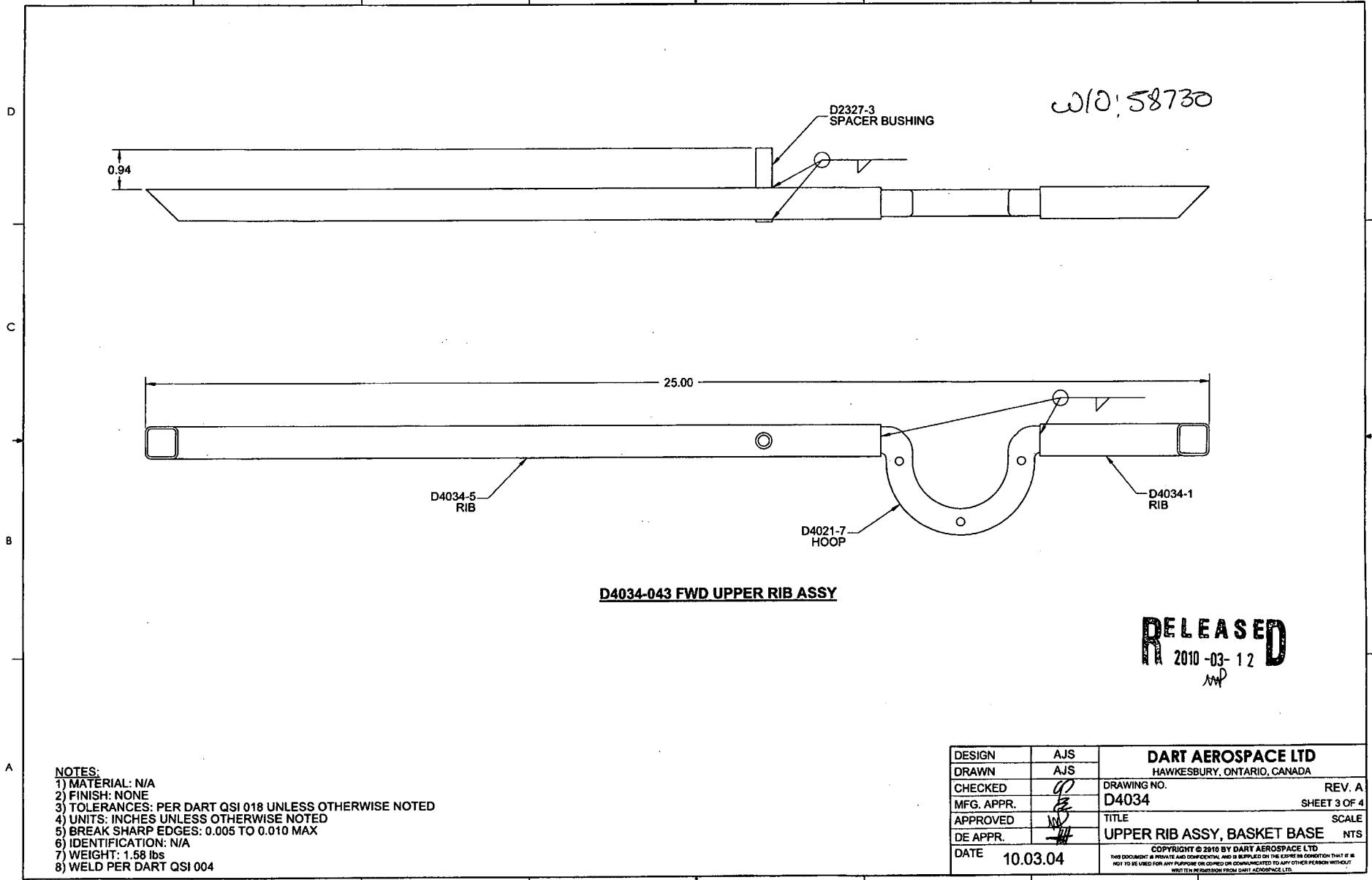
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	
MFG. APPR.	3	REV. A	
APPROVED	MM	D4034	
DE APPR.	MM	SHEET 2 OF 4	
DATE	10.03.04	TITLE	
		SCALE	
		UPPER RIB ASSY, BASKET BASE	
		NTS	

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

